

Work Order ID 61945-2

Monday, September 13, 2010 8:18:41 AM

PRELIMINARY ISSUE

100401

Page 1

Item ID: D4172-10

Revision ID: PRELIM

Item Name: Angle

Start Date: 9/10/2010 Start Qty: 6.00

Required Date: 9/17/2010 Req'd Qty: 6.00

Split

Accept



Setup Start



Stop



Reference:

Approvals: Process Plan: *H* QC:

Date: 10-9-13

Tooling:

Cust Item ID:

Customer:

Date:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4172	PA1	0.00							
100									



Small Fab

Small Fab

Memo

0.00

- 1- Cut to length as per dwg
- 2- Use DT9663 to drill holes in angle, open to size as per dwg
- 3- Deburr holes

9/10/10 10:16



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 - Inspected 10 PA1

Dry only
Sicolor/ku *(X6)*

9/10/10 10:16



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

X6 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61945

Monday, September 13, 2010 8:18:41 AM



Page 2

Item ID: D4172-10

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Angle

Start Date: 9/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date: Tooling: Date:

Run Start



QC:

Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

130

QC
Quality ControlOperation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

BL 10-9-16

140

Packaging
Packaging

Identify as per dwg & Stock Location:

composite
CA

0.00

Jan

AT 10-10-01 (1)

150

QC
Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/10/04 (1)

Memo

0.00

POSITIVE RECALL
 EFFECTIVE 10/10/01 AUTH (1)
 RELEASED 10/10/01 DATE 10/10/01
 PER RELEASED DW
 DATED 10.09.26

10/10/01 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 8:18:45 AM

Page 1

Work Order ID: 61945



Parent Item: D4172-10



Parent Item Name: Angle

Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6203



Angle Extrusion

Manufactured

No

100

f

9.5000

0.0625

0.394737

Location	Loc Qty	Loc Code
MAT	9.5	
45501	9.5	

0.394737

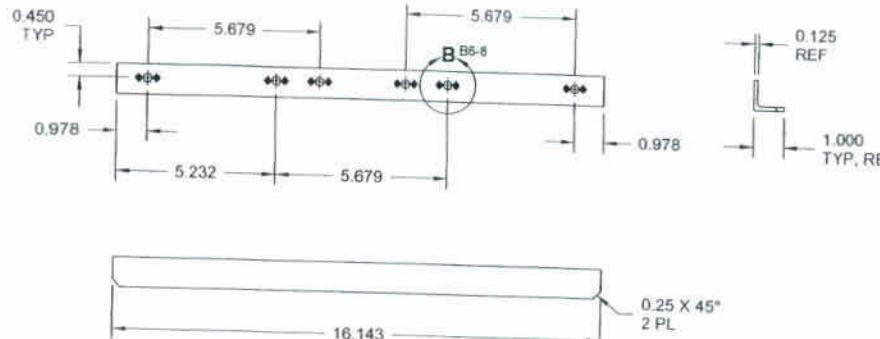
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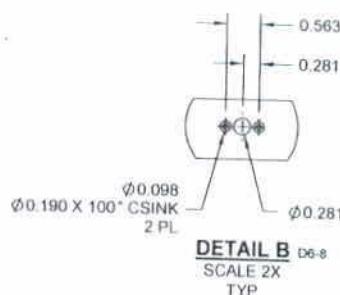
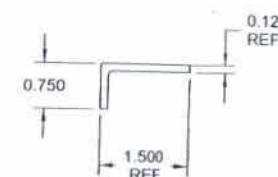
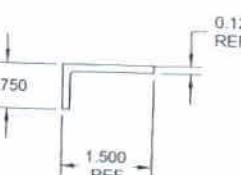
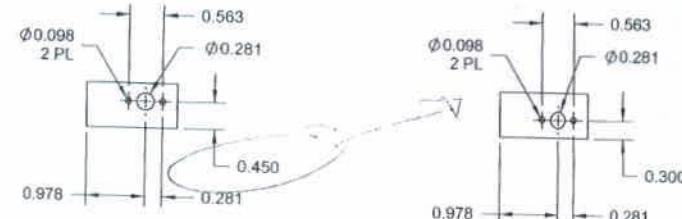
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D4172-7 CROSSBAR



DETAIL B D6-8
SCALE 2X
TYP

NOTES:

- 1) MATERIAL: D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK PER AMS-QQ-A-200/8 REF. DART SPEC. M6061T6A OR D6207
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/10 = 0.01 lbs EACH

8 7 6 5 4 3 2 1

PRELIMINARY ISSUE
10.09.08

41945
B10-9-18

DESIGN	<i>b</i>	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG APPR.		REV. P&I
APPROVED		SHEET 8 OF 8
DE APPR		TITLE
DATE	10.09.03	SCALE
		POD MOUNTING FRAME ASSY NTS

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: B6194.5 B6194.5
Description: Pod Mounting Frame Asy, Angle	Part Number: D4172-10
Inspection Dwg: D4172 Rev: A21	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>EB</u>	Audited by: <u>S</u>	Prototype Approval: N/A		
Date: <u>10/05/16</u>	Date: <u>10/05/16</u> inspected to final dry only	Date: N/A		
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

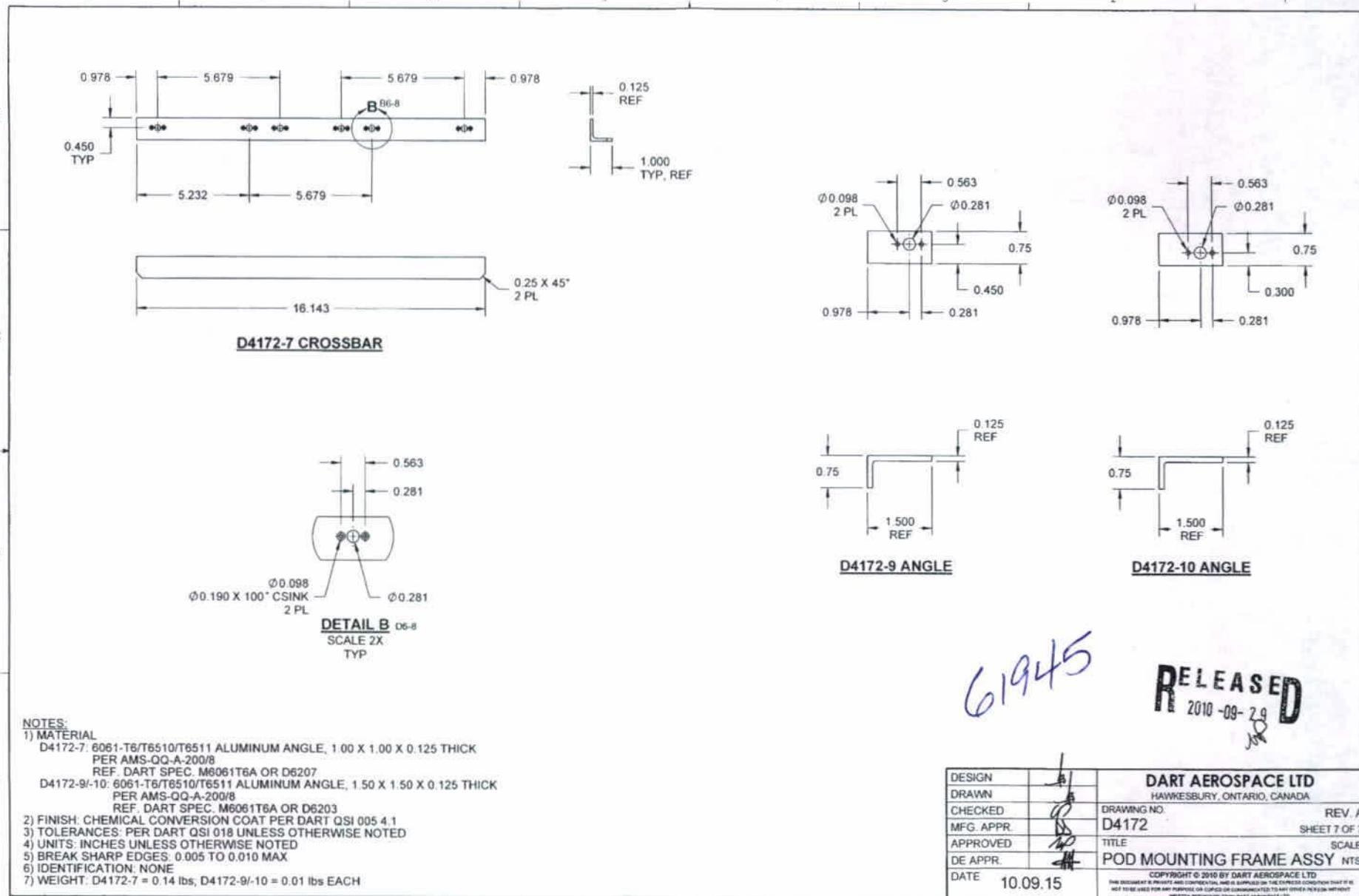
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DESIGN	<i>✓</i>	DART AEROSPACE LTD
DRAWN	<i>✓</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>✓</i>	DRAWING NO. D4172 REV. A
MFG. APPR.	<i>✓</i>	SHEET 7 OF 7
APPROVED	<i>✓</i>	TITLE POD MOUNTING FRAME ASSY NTS
DE APPR.	<i>✓</i>	DATE 10.09.15

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RELEASED
2010-09-29
JK